

Work Order ID 135233

Wednesday, August 05, 2015 12:59:27 PM

135233

Page 1

Ship Aug 6

Item ID: D120-639-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: OEM Replacement Wearplate (s/n 1001 thru 1390)

Start Date: 8/05/15 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 8/17/15 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: JA Date: 15-8-5 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9223	Rev A
IIN-D120-639	Rev A

JA

100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels per PPP D120-639-011	CHG 002							

AUG 06 2015
DAS 27
\$39
REFERENCE ONLY
AUG 05 2015

105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									

② JA AUG 05 2015
DAS 26
9-89

Work Order ID 135233

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135233

Page 2

Item ID: D120-639-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: OEM Replacement Wearplate (s/n 1001 thru 1390)

Start Date: 8/05/15

Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/17/15

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

DAB
27
9-09

2X

AUG 06 2015

120

Packaging

0.00

120

Packaging

Memo

0.00

Packaging

Package and Identify as per PPP D120-639-011

DAB
27
9-09

AUG 06 2015

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

FC 123A

15/8/6

AUG 06 2015

20150806

Picklist Print

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Page 1

Work Order ID: 135233

135233

Parent Item: D120-639-011

D120-639-011

Parent Item Name: OEM Replacement Wearplate (s/n 1001 thru 1390)

Start Date: 8/05/15

Required Date: 8/17/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP D 02.09.13 Re-format, Added MS27130-S30 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2746		Manufactured	No			105	Each	6.0000	1	2			
D2746									**	JA			
Wearplate													

DAS
27
8-09

Location	Loc Qty	Loc Code
ST601	6	
128891	3	
91907	3	

D2656-31		Manufactured	No			105	Each	8.0000	1	2			
D2656-31									**	JA			
Wearplate													

DAS
27
8-09

Location	Loc Qty	Loc Code
ST603	8	
145358	1	
115771	7	

D2656-13		Manufactured	No			105	Each	3.0000	1	2			
D2656-13									**	JA			
Wearplate Fwd													

DAS
27
8-09

Location	Loc Qty	Loc Code
ST603	3	
130906	1	
132477	2	

AUG 05 2015

DAS
26
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 2

Work Order ID: 135233

135233

Parent Item: D120-639-011

D120-639-011

Parent Item Name: OEM Replacement Wearplate (s/n 1001 thru 1390)

Start Date: 8/05/15

Required Date: 8/17/15

Start Qty: 2.00

Required Qty: 2.00

ALS7-1032-130 AEIS8-1032-130 Purchased No

105 Each 3,365.000 36 72

AI S7-1032-130

Rivnut

**** JA**

DAS
26
9-89

DAS
27
9-89

Location Loc Qty Loc Code

CCK003 1462

M128649 1462

FG 50

M128649 50

st549 1853

M128649 1853

m128649 105 Each 18.0000

5 72 10

**** JA**

DAS
26
9-89

D2648-3 Manufactured No

D2648-3

Wearpad

Location Loc Qty Loc Code

FG 8

85490 8

ST601 10

119444 1

132537 9

105 Each 833.0000 40 80

**** JA**

DAS
26
9-89

MS27039-1-08 Purchased No

MS27039-1-08

Screw

AUG 05 2015

Location Loc Qty Loc Code

CA 96

m128636 96

FP001 365

m128636 365

GA 2

125654 2

ST285 370

m128636 370

80

DAS
27
9-89

Wednesday, August 05, 2015 12:59:33 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By																																																									
								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 3

Work Order ID: 135233

135233

Parent Item: D120-639-011

D120-639-011

Parent Item Name: OEM Replacement Wearplate (s/n 1001 thru 1390)

Start Date: 8/05/15

Required Date: 8/17/15

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0332J

Purchased

No

105

Each

2,452.000

40

80

NAS1149D0332.J

JA

Washer

Location

Loc Qty

Loc Code

CA

14

m129682

14

GA

650

m132677

650

ST269

1788

m130325

900

m131624

54

m132677

834

80

MS27130-S30

Purchased

No

105

Each

71.0000

4

8

MS27130-S30

JA

AUG 05 2015

Insert

Location

Loc Qty

Loc Code

ST279

71

100154

71

8

DAS
27
9-89

27

DAS
27
9-89

27

DAS
28
9-89

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9223	REV. A SHEET 1 OF 1
DATE 01.11.19		TITLE WEARPLATE INSERTS	SCALE NTS
A	01.11.19	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS

IIN-D120-639 Rev. A

REF. CANADIAN STC SH01-25

FAA STC: SR01347NY

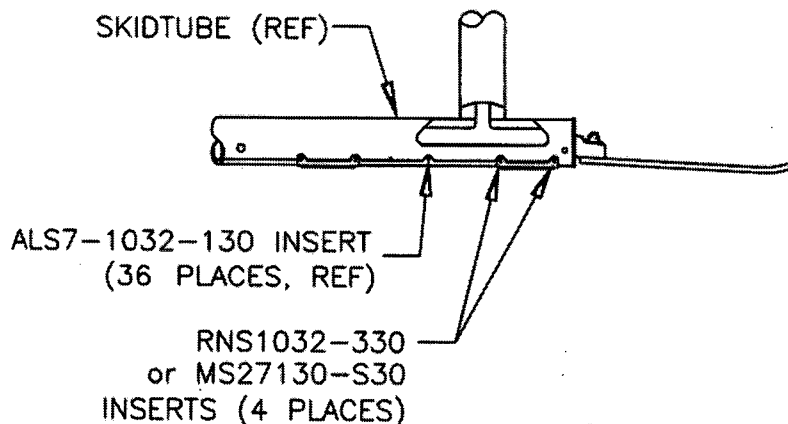
REPLACE (4) AFTMOST ALS7-1032-130 INSERTS WITH (4) RNS1032-330 / MS27130-S30 INSERTS.
UPDATE PARTS LIST AS FOLLOWS:

REPLACE:

QTY -011	QTY -013	Part Number	Description
40	40	ALS7-1032-130	INSERT

WITH:

QTY -011	QTY -013	Part Number	Description
36	36	ALS7-1032-130	INSERT
4	4	RNS1032-330 or MS27130-S30	INSERT



NOTE: OPEN HOLES TO $\phi 0.250$ INSTEAD
OF $\phi 0.297$ FOR THESE 4 INSERTS

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	 D. SHEPHERD (DE # 02)
DATE:	NOV 19, 2001
CERT. NO.:	SH01-25
ISSUE NO.:	1

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Work Order ID 135233

Wednesday, August 05, 2015 12:59:27 PM

135233

Page 1

Item ID: D120-639-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: OEM Replacement Wearplate (s/n 1001 thru 1390)
 Start Date: 8/05/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/17/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: JA Date: 15-8-5 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9223	Rev A								
IIN-D120-639	Rev A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and type labels per PPP D120-639-011	CHG 002							
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									

50 2015/8/5

② JA AUG 05 2015

Ship Aug 6

REFERENCE ONLY**32.2 WEIGHT AND BALANCE**

The following weight and balance information is for the Dart wearplate kits that are being installed. The weight and balance of any wearplates that are being removed from the aircraft is the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D120-639-011 TUNGSTEN CARBIDE WEARPLATE KIT	3.1 lb 1.4 kg	136.0 in 3.45 m	422 in lb 4.8 m kg	±40.7 in ±1.04 m	±126 in lb ±1.5 m kg
D120-639-013 SURFACITE™ WEARPLATE KIT	4.1 lb 1.8 kg	136.0 in 3.45 m	558 in lb 6.2 m kg	±40.7 in ±1.04 m	±167 in lb ±1.9 m kg

32.4 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		D120-639-011	TUNGSTEN CARBIDE WEARPLATE KIT
	X	D120-639-013	SURFACITE™ WEARPLATE KIT
1	1	D2746	WEARPLATE
1	1	D2656-31	WEARPLATE
1	1	D2656-13	WEARPLATE
5		D2648-3	WEARPAD
	5	D2648-7	WEARPAD
40	40	ALS7-1032-130 or AKS7-1032-130 or ALS4-1032-130 or AKS4-1032-130	INSERT
40	40	MS27039-1-08	SCREW
40	40	AN960JD10L	WASHER



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9223	REV. A SHEET 1 OF 1
DATE 01.11.19		TITLE WEARPLATE INSERTS	SCALE NTS
A	01.11.19	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS

IIN-D120-639 Rev. A

REF. CANADIAN STC SH01-25

FAA STC: SR01347NY

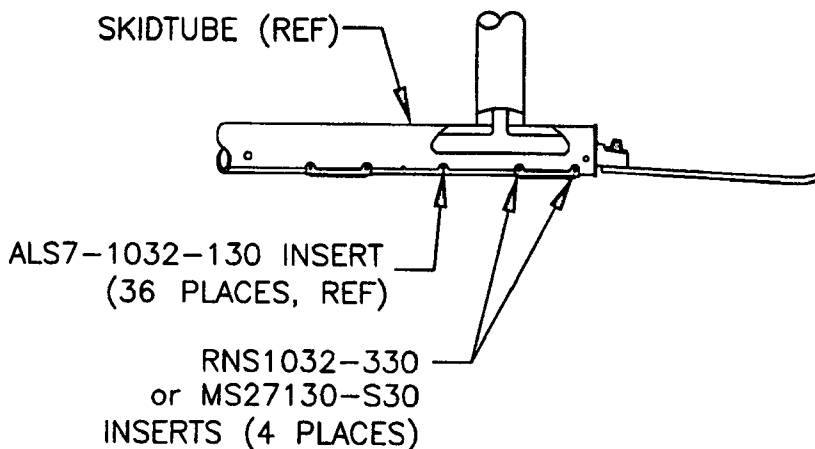
REPLACE (4) AFTMOST ALS7-1032-130 INSERTS WITH (4) RNS1032-330 / MS27130-S30 INSERTS.
UPDATE PARTS LIST AS FOLLOWS:

REPLACE:

QTY -011	QTY -013	Part Number	Description
40	40	ALS7-1032-130	INSERT

WITH:

QTY -011	QTY -013	Part Number	Description
36	36	ALS7-1032-130	INSERT
4	4	RNS1032-330 or MS27130-S30	INSERT



NOTE: OPEN HOLES TO $\phi 0.250$ INSTEAD
OF $\phi 0.297$ FOR THESE 4 INSERTS

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED <i>[Signature]</i>	
BY:	D. SHEPHERD (DE # 02)
DATE:	NOV 19, 2001
CERT. NO.:	SH01-25
ISSUE NO.:	1

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RELEASED
10/15/29 Dcd

PPP

Part Number	D120-639-011
Description	Wearplate Kit

Box Part Number	Tube	Dimension	4 x 4 x 62
			L X W X H
Other Packaging	N/A	Dimension	N/A
Logo Decals	N/A		N/A

Packaging Instructions and Decal Placement

D120-639-011

Wrap wearplate in foam and insert into tube. Add paperwork and hardware. Close tube with clear tape. Add Dart tape over clear tape. Apply label D2729-3 as per instructions in QSI 014 section 4.5.

D2729-1

N/A

D2729-3



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200

WEARPLATE KIT

P/I/N: D120-639-011 CHG002

B/N: BXXXXX

Revision: I

Date: 11.01.26

H:\Admin-qaliso\forms\PPP-1.Rev.A